

Date: Thursday, 17/04/2008 10:59:25 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 38662			<i>101</i>		
Estimate Number	: 10764					
P.O. Number	:			Part Number	: D2876	
This Issue	: 17/04/2008	S.O. No. :		Drawing Number	: D2876 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 36275			Drawing Revision	: B	
Written By	:			Material	: NOTE:1 BLANK MAKES 4 PARTS	
Checked & Approved By	: <i>JLJ 08.4.17</i>			Due Date	: 15/05/2008	
Comment	: Esr Rev:B 00.05.19 Added inspect level 8 EC			Qty:	120	
	Est Rev:C Now M6061-T6 06-06-23			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S100	6061-T6 .100 Sheet 8, Comment: Qty.: 0.0542 sf(s)/Unit Total : 6.5016 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.100" Thick Batch: <i>8008 18-4-21</i>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D 2876 Dwg Rev: <i>B</i> Prog Rev: <i>B</i> <i>(B 8-4-21)</i> 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>(B 8-4-21)</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>5 08/04/22</i> <i>(144)</i> <i>call</i> Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>(144)</i> Comment: SMALL & MEDIUM FAB RESOURCE 1 Remove tabs and Tumble <i>8008/4/22 927 08/04/22</i> <i>(44)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>Fd 08/04/29 1441</i>
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>SL 08-04-24 1442</i>
8.0	PACKAGING 1 	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>8751</i> <i>Ldy/24 1443</i>
9.0	QC21 	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE <i>08/04/29 1444</i>
Job Completion 		<i>MFR 08-04-28</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38662
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	<u>8-4-21</u>	Date:	<u>08/04/22</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.15	Removed 0.250 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

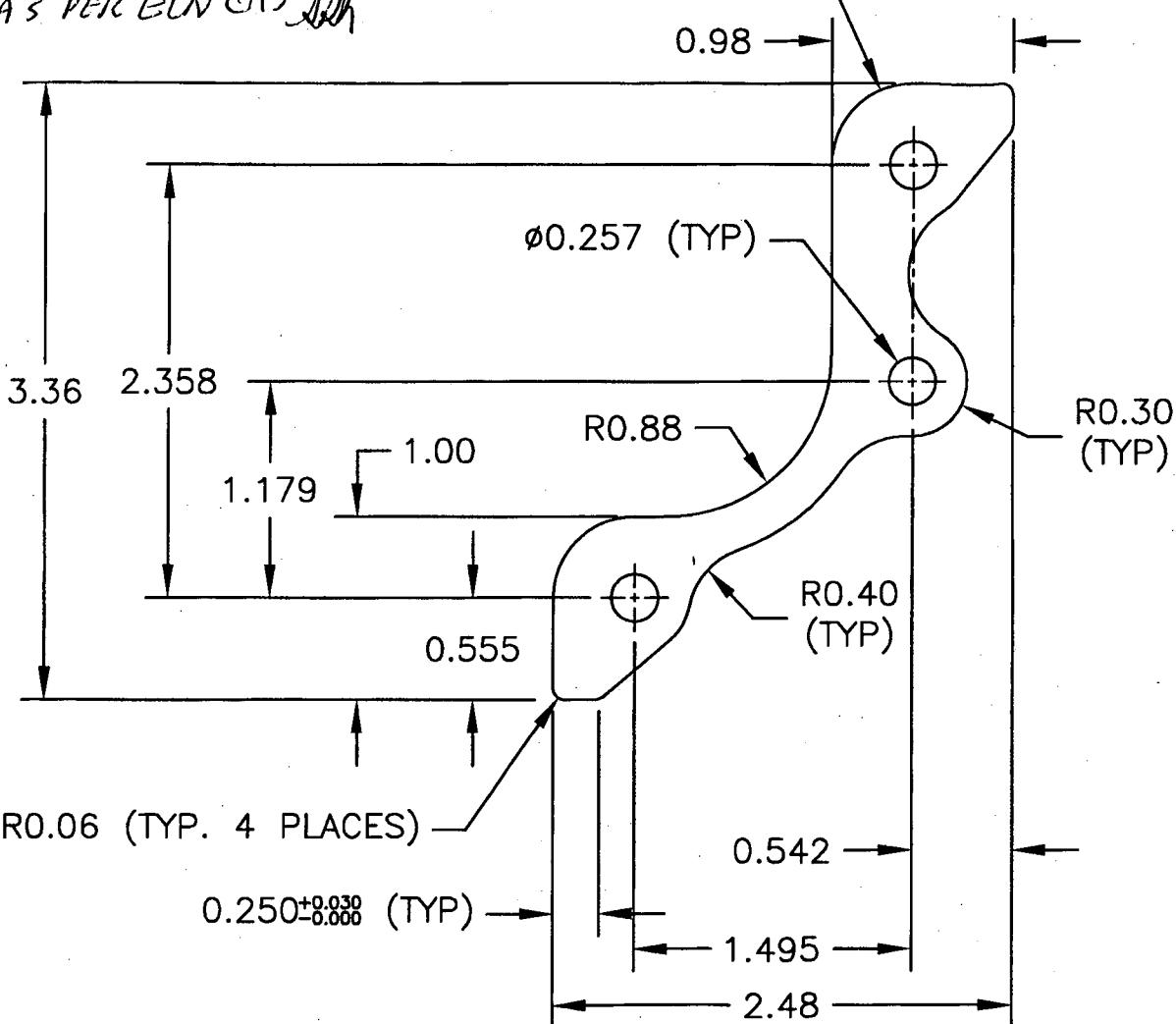
DESIGN	4P	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	M	DRAWING NO.	REV. B
				D2876	SHEET 1 OF 1
DATE	06.06.02			TITLE	SCALE
				SADDLE SPACER	1:1
A	99.02.23	NEW ISSUE			
B	06.06.02	MATERIAL CHANGE			

RELEASED

06.06.22

AS PER ECN 813

R0.44 (TYP 2 PLACES)

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38662

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